

Date: Monday, 3/17/2008 11:56:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 BEARPAW
 Job Number : 38021A
 Estimate Number : 12480
 P.O. Number :
 This Issue : 3/17/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1/ Type : MACHINED PARTS
 Previous Run : 37315A
 Part Number : D35291
 Drawing Number : D3529 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 3/30/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 108 03 17
 Comment : Est Rev: A New Issue 06-06-28 JLM

↑
only 12 TL.

NOT 24 gals

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 1.3283 sf(s)/Unit Total: 15.9390 sf(s)

Pick:

blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"(MUHMWB10)

Batch: M107062 → 3 parts

M106161 → 9 parts

SA 08/04/30

2.0 MFG ENGINEERING MFG ENGINEERING



Comment: MFG ENGINEERING
 Program Batch Number

SA 08-04-16

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

HA/SA 08/04/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA/SA 08/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:43 AM
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Process Sheet

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Drawing Name: R44 BEARPAW

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Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 08/05/01

(12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP-38021

JS 08/05/02

(12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06

Job Completion



U 08-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38021A
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

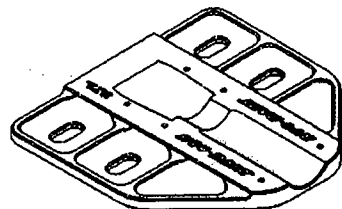
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.502	/			
B	0.07 x 45°	+/-0.030 x 0.5°	.06 x 45°	/			
C	R0.25	+/-0.030	R.23	/			
D	0.250	+/-0.010	.245	/			
E	0.625	+/-0.010	.620	/			
F	0.950	+/-0.010	.951	/			
G	1.63	+/-0.030	1.619	/			
H	12.14	+/-0.030	12.14	/		Tape	
I	10.50	+/-0.030					
J	5.70	+/-0.030	5.687	/			
K	0.375	+/-0.010	.374	/			
L	0.525	+/-0.010	.523	/			
M	0.13 x 45°	+/-0.030 x 0.5°	.140 x 45°	/			
N	R0.50	+/-0.030	R.50	/			
O	12.76	+/-0.030	12.75	/		Tape	
P	3.38	+/-0.030	3.38	/			
Q	3.75	+/-0.030	3.75	/			
R	5.187	+/-0.010	5.187	/			
S	5.25	+/-0.030	5.25	/			
T	7.13	+/-0.030	7.125	/			
U	Ø0.260	+0.006/-0.001	Ø.260	/			
V	0.30	+/-0.030	.295	/			
W	0.93	+/-0.030	.927	/			
X	1.30	+/-0.030	1.290	/			
Y							

Measured by:	SD	Audited by:	gml	Prototype Approval:	N/A
Date:	08/04/01	Date:	08/05/01	Date:	N/A

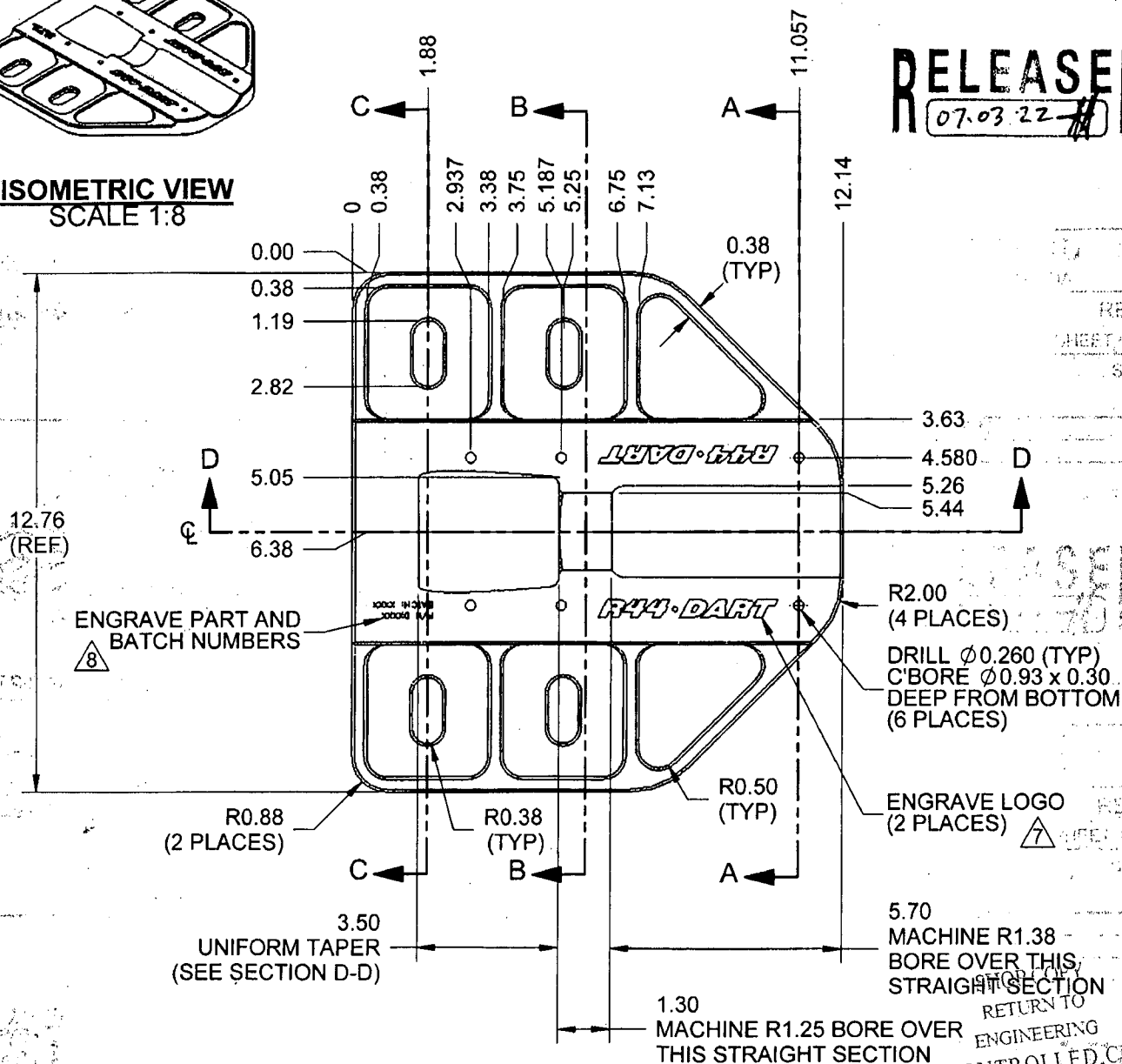
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	

DESIGN CB		DRAWN BY CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B		APPROVED [Signature]		DRAWING NO. REV. A D3529 SHEET 1 OF 2	
DATE 07.01.04		TITLE SCALE R44 BEARPAW 1:4			
REV A	DATE 07.01.04		DESCRIPTION NEW ISSUE		



ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22



D3529-1 R44 BEARPAW

NOTES:

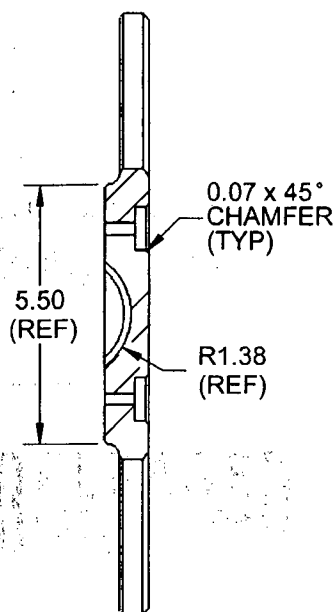
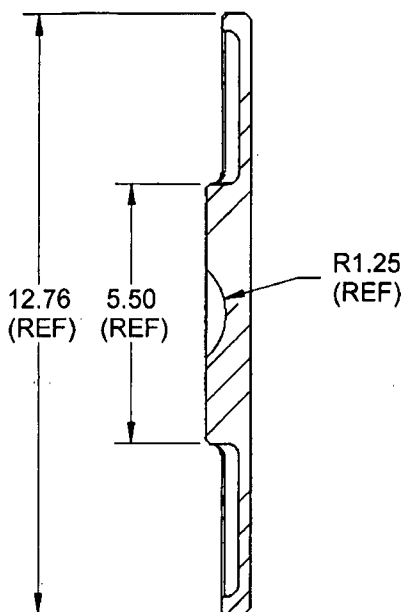
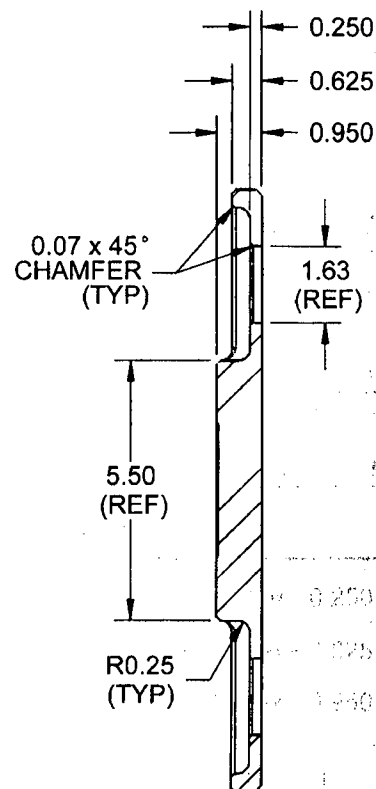
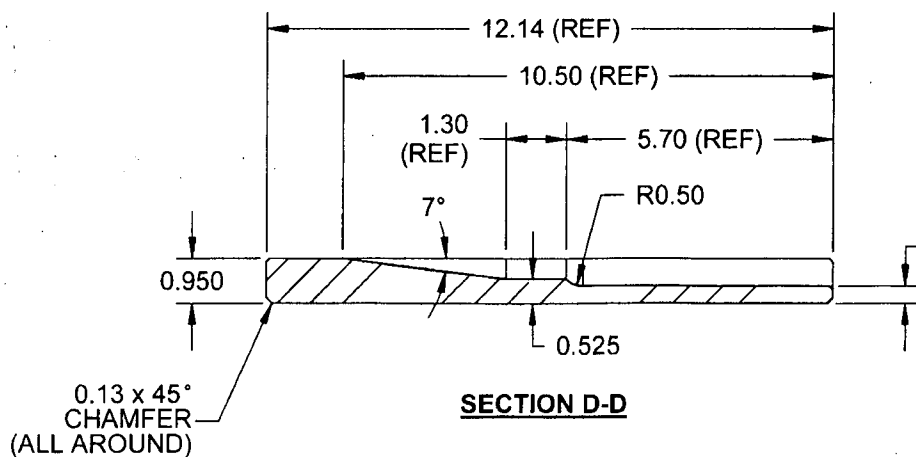
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE
2) FINISH: NONE
3) PART IS SYMMETRIC ABOUT C
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED M	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
07.03.22**SECTION A-A****SECTION B-B****SECTION C-C****SECTION D-D**

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WITHOUT NOTICE
WORK ORDER
NO. 38021 A

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